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RB KIT 407M-15
Job Sheet 200980



Part No: RB KIT 407M-15

Job Qty: 10 pcs

Part Name: Gauge Pin .1200" dia.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/20/19

Job Tracking No:

Due Date: 10/14/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB KIT 407M REV.D IPP REV A 18.01.29 NEW ISSUE RQ VERIFIED BY DP/IPP Rev B 18.03.08 DWG update Rev. C DP Verify DD/IPP Rev. C 19.01.24 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	10 pcs	10/14/19		0.00	0.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
120	QC 5	10 pcs	10/14/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	10 pcs	10/14/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		

GP 19-10-01

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					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - SA	10 pcs	10/14/19	0.00 0.00	QC 21 - SA - 21	DAS 21 OCT 08 2019
					QC 21 - SA - 70	9-85
					QC 21 - SA - 53	

Part Op 100 - 1-Cut pin in half. 2-Deburr 3-Put pin in small sealable plastic bag with a small amount of LPS 2 to prevent corrosion.
 Descriptions: 4-Package as per note 10.
 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
21135A54	Plug Gauge	5 Ea (.5 ea)	100-Small Fab - 1	5152003.

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	21135A54	5	73	0

Part Specifications	
Specifications could not be found.	

Plex 10/1/19 11:39 AM dart.leclair.mathieu

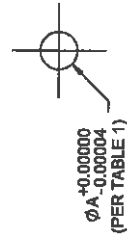


TABLE 1
GAUGE PIN DIMENSIONS

PART NUMBER	ϕA	B	PURCHASE PART NUMBER (McMASTER CARR)
RB KIT 407M-01	$\phi 0.2400$	1.00"	21135A52 OR EQUIV.
RB KIT 407M-03	$\phi 0.4000$	1.00"	21135A53 OR EQUIV.
RB KIT 407M-05	$\phi 0.5400$	1.00"	21135A53 OR EQUIV.
RB KIT 407M-07	$\phi 0.6800$	1.00"	21135A53 OR EQUIV.
RB KIT 407M-09	$\phi 0.8000$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-11	$\phi 0.9600$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-13	$\phi 1.0800$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-15	$\phi 1.2000$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-17	$\phi 1.4400$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-19	$\phi 1.4400$	0.25"	21135A54 OR EQUIV.
RB KIT 407M-21	$\phi 1.6000$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-23	$\phi 1.6000$	0.25"	21135A54 OR EQUIV.
RB KIT 407M-25	$\phi 1.7280$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-27	$\phi 1.7280$	0.25"	21135A54 OR EQUIV.
RB KIT 407M-29	$\phi 1.8000$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-31	$\phi 1.9200$	1.00"	21135A56 OR EQUIV.

RB KIT 407M-01 THRU -31 ϕ .XXXX. CLASS X PLUG NO-GO GAUGE

NOTES:
1) MATERIAL: SEE TABLE 1 FOR MATERIAL SPECIFICATION
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A

DESIGN DRAWN	KPT	MBB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	REV. D	REV. D
MFG. APPR.	DP	TOOL PART #	RB KIT 407M
APPROVED	VP	TITLE	SPLINE MEASURING KIT
DATE	1/17/2019	SHEET 3 OF 3	SCALE NTS

SHOP COPY

UNCONTROLLED COPY

200980 M65

19-09-20

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐			DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ Machining ☐ ☐ ☐ Large Fab ☐ ☐ ☐			Cross tube ☐ ☐ ☐ Small Fab ☐ ☐ ☐ Finishing ☐ ☐ ☐			Eng. (Non-AW) ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐			Engineering ☐ ☐ ☐ Water Jet ☐ ☐ ☐ Supplier ☐ ☐ ☐ Quality ☐ ☐ ☐							
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QS1042)															
Description Work Order Deviation				Disposition																	
Root Cause Operator ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ Material ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ Human Factors ☐ ☐ ☐				FAULT CATEGORY Contamination ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ Fit/Function ☐ ☐ ☐						Power Loss/Surge ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ Weld ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐						Positioned Wrong ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ Drawing ☐ ☐ ☐ Finish ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ Misread ☐ ☐ ☐					
				Pressure/Forced ☐ ☐ ☐ Bending ☐ ☐ ☐ Crushing ☐ ☐ ☐ Cracks ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ Mislabeled ☐ ☐ ☐						Completed By Lead hand / Supervisor QC / QA Coordinator											
				Other/Details:																	